



Dart Aerospace Ltd.
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D2873-043
Job Sheet 186224



Part No: D2873-043

Job Qty: 20 ea

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		12/7/18	0.00	0.00	Start Up Machining-1		9/18/18/12/10
100	Bandsaw	20 pcs		12/7/18	0.00	0.10	Bandsaw1		
110	CNC Vertical Machining	20 pcs		12/7/18	0.04	5.28	HAAS1-2		9/18/18-12-4
120	QC	20 pcs		12/7/18	0.00	0.00	QC2 Machining-1		9/18/18-12-4
130	QC	20 pcs		12/7/18	0.00	0.00	QC8 Machining-1		9/18/18/12/10
150	QC	20 pcs		12/7/18	0.00	0.00	QC5		38
160	HandFinish	20 pcs		12/7/18	0.00	0.25	HandFinish1		D.R. 18/12/10
170	QC	20 pcs		12/7/18	0.00	0.00	QC7-1		36 DAS
180	Small Fab	20 pcs		12/7/18	0.00	0.68	Small Fab-2		9-89 36
190	QC	20 pcs		12/7/18	0.00	0.00	QC5		38 9-89
200	Packaging	20 pcs		12/7/18	0.00	0.00	Packaging3-1	LG050	18-12-12
210	QC21-SA	20 Ea		12/7/18	0.00	0.00	QC21		DAS 21

Part Op 100 - Cut blanks: 1.000" x 0.375" x 3.700" long

Descriptions: 110 - Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev A Folio Rev AA

180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-043

200 - LOCATION : LG050

DEC 12 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	6.1660 ft (.3083 ea)	90-Start up Operation	505624-6.25
MS20426AD4-6	Rivet	120 Ea (6 ea)	180-Small Fab	5093088-1
MS21075L5	Nut Plate	60 Ea (3 ea)	180-Small Fab	5039328-25
				5127335-32

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X1.000	6	18	0
180-Small Fab	MS20426AD4-6	120	1,775	0
	MS21075L5	60	284	0



Container No: S133736



Part: D2873 - 043

Job No: 186224

Serial No/Batch: S133736

Revision:

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Part Specifications

Specifications could not be found.

Plex 11/13/18 9:06 AM Dart.lajeunesse.marie

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / U

Inspector:
Exp Date:
Instructions: Various STC's

Date: 12/02/10

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐
Part No. _____		Machining ☐
NCR No. _____		Thermoforming ☐
		Large Fab ☐

Date :	Step #:	QTY Effective
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[illegible]

**QC / QA Coordinator
Approval**

Root Cause			FAULT CATEGORY			
Environment		No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Design		Operator	Bending	Set-up	Folio/Program	Outside Dimensions
Doc/Data		Offset/Set-up	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Equip/Tooling		Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect
Handling/Pre		Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material		Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved
Internal Transport		Poor Information	Crushing	Countersink	Off-set	Drawing
Tribal Knowledge		Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish
LOA		Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread
Substation		Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date		Manufacturing Process				
Misidentified		Past Due	OTHER :			

DART AEROSPACE LTD		Work Order: 186224
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.505	✓		CNC20	
2.000	+/-0.010	2.000	✓		CNC20	
0.750	+/-0.010	.751	✓		CNC20	
1.000	+/-0.010	1.000	✓		CNC20	
0.250	+/-0.010	.253	✓		CNC20	
1.000	+/-0.010	1.000	✓		CNC20	
2.000	+/-0.010	2.000	✓		CNC20	
3.000	+/-0.010	3.000	✓		CNC20	
Ø0.128	+0.005/-0.001	Ø.130	✓		PW	
0.359	+/-0.010	.359	✓		CNC20	
Ø0.316	+0.006/-0.001	.317	✓		PW	
1.000	+/-0.010	1.000	✓		CNC20	
0.250	+/-0.010	.251	✓		CNC20	
0.061	+/-0.010	.058	✓		CNC20	
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.228 x .124	✓		CNC20	

Measured by: Fred	Audited by: [Signature]	Prototype Approval:	N/A
Date: 12-12-4	Date: 11/12/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM	[Signature]

